

# Work Order ID 51782



Page 1

Thursday, September 03, 2009 8:15:30 AM

Item ID: D350-591-311

Accept



Setup Start



Revision ID: B

Item Name: Heli-Access-Step, Long LH

Stop



Start Date: 9/3/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 9/25/2009 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

*RL*

Date:

*09-03*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3272

Rev B

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

*6 09/02/30*

*HJ for BG 09/09/29*

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Bevel end for welding FWD ONLY *lh*

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg

D3272

A/R ☐ Aluminum Rod

3-Grind End Plate flush

*m111311*  
*m111494*  
*lh*

*11 09.09.17*

*10 /*

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Page 2

Item ID: D350-591-311

Accept



Setup Start



Revision ID: B

Stop



Item Name: Heli-Access-Step, Long LH

Start Date: 9/3/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 9/25/2009 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds  Memo	0.00  0.00				10	0	BE 09/09/17	
130  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00				10	0		
140  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00				10	0		

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Thursday, September 03, 2009 8:15:30 AM

Page 3

Item ID: D350-591-311

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Revision ID: B

Item Name: Heli-Access-Step, Long LH

Start Date: 9/3/2009 Start Qty: 10.00

Required Date: 9/25/2009 Req'd Qty: 10.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

M.H

09/09/22

10X

160



Large Fab

Large Fab

Large Fab

Memo

Assemble Leg Assembly as per Dwg D3272.  
Leave one rivet out until welding is complete.

0.00

0.00

Ph

09.09.23

10

170



QC

Quality Control

QC5- Inspect part completeness to step on W/Q

Memo

0.00

0.00

09/09/22

**Work Order ID 51782**

Thursday, September 03, 2009 8:15:30 AM



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Item ID: D350-591-311

Accept



Setup Start



Revision ID: B

Stop



Item Name: Heli-Access-Step, Long LH

Start Date: 9/3/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 9/25/2009 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180		0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1-Bevel Aft end for welding <i>lh</i>								
	2-Inspect for foreign object as per QSI 024 <i>lh</i>								
	3-Weld Aft End Plate as per QSI 004 & Dwg D3272 <i>lh</i>								
	A/R <input type="checkbox"/> Aluminum Rod <input checked="" type="checkbox"/> <i>mill 11/3/11</i>								
	4-Grind End Plate flush <i>lh</i>								
	5-Install last rivet as per Dwg. <i>lh</i>								
190	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC	Memo	0.00							
Quality Control									

*lh 09-09-23**10* *Ø**x10* *Ø* *BE 09/09/23*

**Work Order ID 51782**

Thursday, September 03, 2009 8:15:30 AM



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Item ID: D350-591-311

Accept



Setup Start



Revision ID: B

Stop



Item Name: Heli-Access-Step, Long LH

Start Date: 9/3/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 9/25/2009 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

200

QC5- Inspect part completeness to step on W/O

0.00

2) 09/01/23

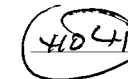


QC

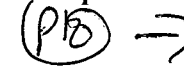
Memo

0.00

Quality Control



d



210

Chemical Conversion Coat per QSI005 4.1

0.00



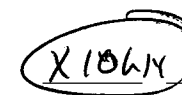
HandFinish

Memo

0.00

Hand Finishing

JL 09/09/23



d

220

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

M112260

START TIME: 11:30 AM  
OVEN TEMPERATURE: 320°F  
FINISH TIME: 12:00 PM

\* pressure-wash

JL 09/09/23



d

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-591-311 PAR #: \_\_\_\_\_ Fault Category: Prod-Large Fals NCR: (Yes) No DQA: / Date: 05/10/05  
 Resolution: Re-work Disposition: Re-work QA: N/C Closed: / Date: 05/10/05

NCR: <u>51782</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>9/9/23</u>	<u>160</u>	Found in one step a foreign object during inspection in side of step R.C. L.A.A. did not remove <del>foreign object</del> "Ensure"	<u>/</u> <u>BS142</u>	Drill small hole in aft cap AND • Remove all foreign objects from <del>inside</del> inside of step.	<u>/</u> <u>09-09-23</u>	<u>S</u> <u>09/09/23</u>	<u>/</u> <u>BS142</u>	<u>S</u> <u>09/09/23</u>
			<u>/</u> <u>BS142</u>	Remove on rivet if necessary <u>MS20600AD4W4 B&amp; M112385</u>	<u>/</u> <u>09-09-23</u>	<u>S</u> <u>09/09/23</u>	<u>/</u> <u>BS142</u>	<u>S</u> <u>09/09/23</u>
			<u>/</u> <u>BS142</u>	Re weld as per AS7004 <u>A/R M11311</u>	<u>/</u> <u>09-09-23</u>	<u>S</u> <u>09/09/23</u>	<u>/</u> <u>BS142</u>	<u>S</u> <u>09/09/23</u>
			<u>/</u> <u>BS142</u>	Build weld smooth.	<u>/</u> <u>09-09-23</u>	<u>S</u> <u>09/09/23</u>	<u>/</u> <u>BS142</u>	<u>S</u> <u>09/09/23</u>
			<u>/</u> <u>BS142</u>	Re inspect AC9.	<u>BE</u> <u>09/09/23</u>	<u>S</u> <u>09/09/23</u>	<u>/</u> <u>BS142</u>	<u>S</u> <u>09/09/23</u>

NOTE: Date &amp; initial all entries

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Page 6

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

230

Wing Walk as per dwg QSI005 4.4 Batch

0.00

BR 09-09-28.

10 LH



HandFinish

Memo

0.00

Hand Finishing

240

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

9/9/20

10x SV

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

9/9/20

10x SV

\_\_\_\_\_

Thursday, September 03, 2009 8:15:31 AM

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[illegible]

**Journal of Interpersonal Violence** 26(10)br/>© The Author(s) 2011  
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Chapel Hill, NC 27599-0085  
**E-mail address:** jay@unc.edu

(b) (7)(C), (b) (7)(D)

**Insp.  
Stamp**

⇒ 607/07/30



0.00

## Quality Control

0.00



### Packaging

## Memo

0.00

## Packaging

Identify and pack for shipping as per PPPD350-591-311

Location: \_\_\_\_\_

0.00



QC

## Memo

0.00

## Quality Control

Pg 5/30 (20)

09/10/01

MF 09-10-01



# Picklist Print

Thursday, September 03, 2009 8:15:37 AM

Page 1

Work Order ID: 51782

Parent Item: D350-591-311RevB

Parent Item Name: Heli-Access-Step, Long LH


Comments:

Start Date: 9/3/2009

Required Date: 9/25/2009

Start Qty: 10.00



Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3067-1RevA  End Plate		Manufactured	No			110	Each	35.0000	10.0000		09-09-16	

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST 351546                      35  
51104                      35

D3272-1RevB  Step		Manufactured	No			110	Each	0.0000	10.0000			
MS21042L5 f2  Nut		Purchased	No			110	Each	1,363.000	20.0000			

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST 1363  
110382 10  
111636 353  
112314 1000

5x  
5x  
351781 09-09-14 (10X)  
9/9/09 (10X)

11636 Sp

# Picklist Print

Page 2

Thursday, September 03, 2009 8:15:37 AM

Work Order ID: 51782

Parent Item: D350-591-311RevB

Parent Item Name: Heli-Access-Step, Long LH


Comments:

Start Date: 9/3/2009

Required Date: 9/25/2009

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3065-041RevB		Manufactured	No			160	Each	42.0000	10.0000			
												
Step Leg Assembly Hi												

*Handwritten:* 09-09-22

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST

22

50095 *No more*

2

51125

20

Main Warehouse

WA

20

50095

20

D3066-1RevB

Manufactured No

160

Each

40.0000

20.0000



Spacer

*Handwritten:* 09-09-22

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST

40

851545

*No more* → 50383

40

*Handwritten:* 10

Thursday, September 03, 2009 8:15:37 AM

Shop Packet Print

Page 2

# Picklist Print

Thursday, September 03, 2009 8:15:37 AM

Work Order ID: 51782



Parent Item: D350-591-311RevB



Parent Item Name: Heli-Access-Step, Long LH

Start Date: 9/3/2009

Required Date: 9/25/2009

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3219-1RevA		Manufactured	No			160	Each	61.0000	20.0000			
Plate												

*Handwritten:* 09.09.16 (20X)

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST

61

47296

17

51186

44

MS20600-AD4W4

Purchased

No

180

Each

2,999.000

160.0000



Rivets

*Handwritten:* 20

*Handwritten:* 09.09.20

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST

2999

110731

215

111359

46

111477

74

112082

264

112314

2000

112385

400

*Handwritten:* No more →

*Handwritten:* 120

*Handwritten:* 40

# Picklist Print

Page 4

Thursday, September 03, 2009 8:15:37 AM

Work Order ID: 51782



Parent Item: D350-591-311RevB



Parent Item Name: Heli-Access-Step, Long LH



Start Date: 9/3/2009

Required Date: 9/25/2009

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3-35A  Bolt		Purchased	No			260	Each	541.0000	20.0000 		9/9/08	100

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

541

106993

12

110467

29

112314

500

112314 SP

# Picklist Print

Thursday, September 03, 2009 8:15:37 AM

Work Order ID: 51782



Parent Item: D350-591-311RevB



Parent Item Name: Heli-Access-Step, Long LH

Start Date: 9/3/2009

Required Date: 9/25/2009

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN4-13A		Purchased	No			260	Each	919.0000	80.0000			
---------	--	-----------	----	--	--	-----	------	----------	---------	--	--	--



Bolt

9/9/08 @ SP

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

Return 2009

8

111477

8

Main Warehouse

ST

911

107321

1

107534

5

107959

23

109285

37

110552

66

110865

3

111477

9

111925

7

112314

760

17406

0

112314

# Picklist Print

Thursday, September 03, 2009 8:15:37 AM

Work Order ID: 51782

Parent Item: D350-591-311RevB

Parent Item Name: Heli-Access-Step, Long LH

Comments:

Start Date: 9/3/2009

Required Date: 9/25/2009

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN5-36A <i>x2</i>		Purchased	No			260	Each	611.0000	20.0000			



*HB* Bolt

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	611
109545	11
110467	7
110731	4
112243	39
112314	500
112385	50

*112314 SP*

AN960JD10 *x4*



*WC* Washer

Purchased

No

260

Each

2,357.000

40.0000

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	2357
105442	95
109059	2
109840	23
110985	202
111279	13
111668	22
112314	1000
112369	1000

*112369 SP*

*9/9/28 QDW SU*

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# Picklist Print

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Thursday, September 03, 2009 8:15:37 AM

Work Order ID: 51782



Parent Item: D350-591-311RevB



Parent Item Name: Heli-Access-Step, Long LH

Start Date: 9/3/2009

Required Date: 9/25/2009

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD416	216	Purchased	No			260	Each	9,093.000	160.0000			
											9/9/28	TDW

S

+D Washer

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
Return 2009	18	
111279	18	
Main Warehouse		
ST	9075	
102929	2	
105906	4	
107321	23	
107939	114	
108161	553	
108827	31	
109249	69	
110523	340	
111279	101	
111916	2951	
112314	4887	
16941	0	

111916 SP

# Picklist Print

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Thursday, September 03, 2009 8:15:37 AM

Work Order ID: 51782

Parent Item: D350-591-311RevB

Parent Item Name: Heli-Access-Step, Long LH

Comments:

Start Date: 9/3/2009

Required Date: 9/25/2009

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD516 <i>ky</i>		Purchased	No			260	Each	1,257.000	40.0000			



*Washer*

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST

1257

100564

2

106167

6

107534

34

107959

43

108246

46

108672

2

109059

49

109752

22

110363

46

110523

57

111279

43

112082

407

112314

500

D2230-3RevG *ky*



*Lug*

Manufactured No

260

Each

0.0000

40.0000



*112082 SP*

*51568 SP*

*9/9/09 70x 54*

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# Picklist Print

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Thursday, September 03, 2009 8:15:37 AM

Work Order ID: 51782

Parent Item: D350-591-311RevB

Parent Item Name: Heli-Access-Step, Long LH

Comments:

Start Date: 9/3/2009

Required Date: 9/25/2009

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2618RevB1	X2	Manufactured	No			260	Each	371.0000	20.0000			



6  
+10 Bushing

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST039

20

50659

20

Main Warehouse

ST39

351

50989

200

51189

151

D2856-400RevA

X2 @ 7.2"

Manufactured

No

260

f

336.2077

6.0000



6  
+10 Abrasion Strip

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

122.8077

42437

44.93

46543

77.8777

Main Warehouse

ST403

213.4

50593

213.4

51189 SV

50593 SV

9/9/20 Fox

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# Picklist Print

Thursday, September 03, 2009 8:15:37 AM

Work Order ID: 51782

Parent Item: D350-591-311RevB

Parent Item Name: Heli-Access-Step, Long LH



Comments:

Start Date: 9/3/2009

Required Date: 9/25/2009

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3067-1RevA  End Plate		Manufactured	No			260	Each	35.0000	10.0000		9/9/09.22	

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST B51546                      35  
51104                      35

10

S D3235-1RevA x2



Manufactured No

260

Each

213.0000

20.0000



9/9/09 100 SP

ft Mounting Lug

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST                      213  
45398                      4  
46745                      109  
47969                      100

46745 30

# Picklist Print

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Thursday, September 03, 2009 8:15:37 AM

Work Order ID: 51782

Parent Item: D350-591-311RevB

Parent Item Name: Heli-Access-Step, Long LH

Comments:

Start Date: 9/3/2009

Required Date: 9/25/2009

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3278-041RevC		Manufactured	No			260	Each	60.0000	10.0000			

Support Assembly

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

20

47886

20

Main Warehouse

ST471

40

51191

40

MS21042L3

Purchased

No

260

Each

3,808.000

20.0000

Nut

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

3808

110844

32

111274

284

111668

992

112314

2000

112385

500

51191 80

9/9/08 102

111274 80

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# Picklist Print

Thursday, September 03, 2009 8:15:37 AM

Work Order ID: 51782



Parent Item: D350-591-311RevB



Parent Item Name: Heli-Access-Step, Long LH

Start Date: 9/3/2009

Required Date: 9/25/2009

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L4	86	Purchased	No			260	Each	8,411.000	80.0000			



Nut

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

8411

107499

5

110507

369

111827

5996

112314

2000

15924

0

8182

41

112314

9/9/28 TDD SQ

**DART**

DESIGN <i>GP</i>	DRAWN BY <i>B</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

**RELEASED**07.06.04 *H*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

**GENERAL NOTES:**

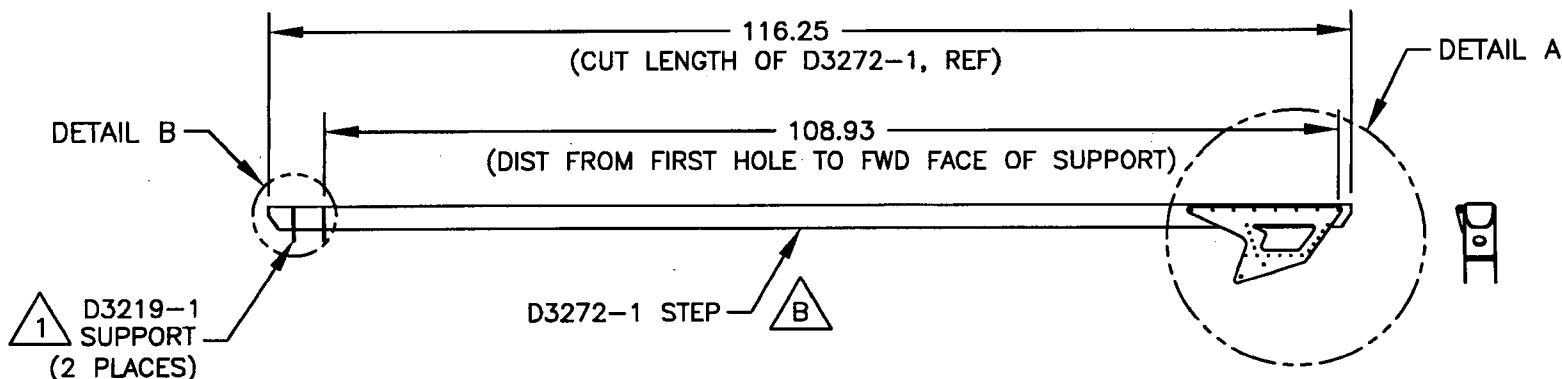
- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

51782

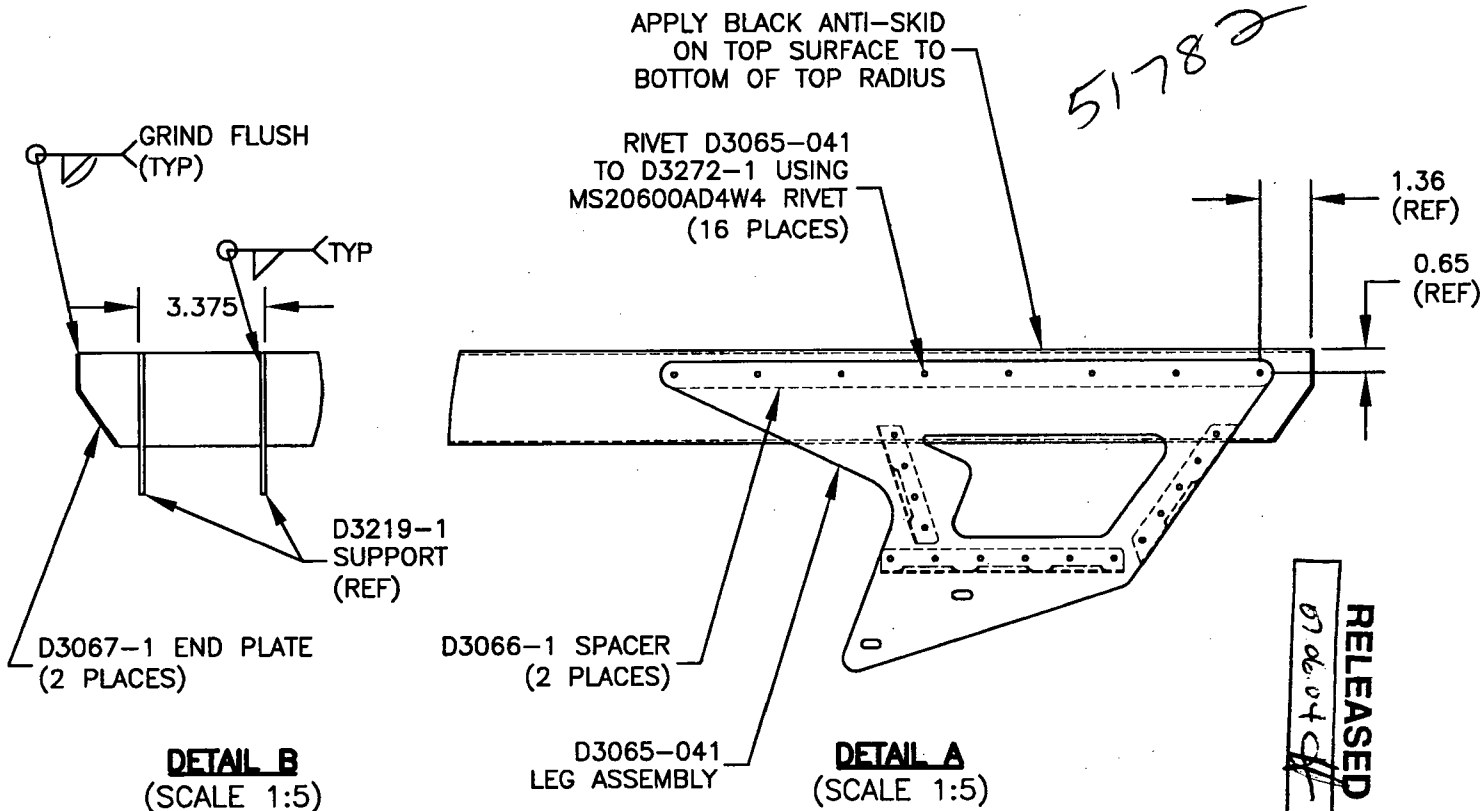
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**DART**



**D3272-041 STEP ASSEMBLY (LH. SHOWN)**  
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



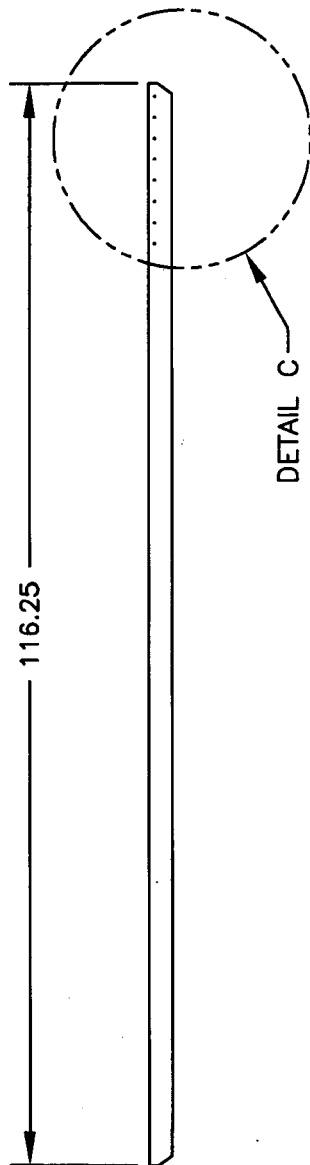
DESIGN	AP	DRAWN BY	AS	DART AEROSPACE LTD
CHECKED	CE	APPROVED	AS	HAMKESBURY, ONTARIO, CANADA
DATE	07.05.18	DRAWING NO.	D3272	REV. B
		TITLE	STEP ASSEMBLY, HI LONG	SHEET 2 OF 3
				SCALE 1:20

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DESIGN 4P	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

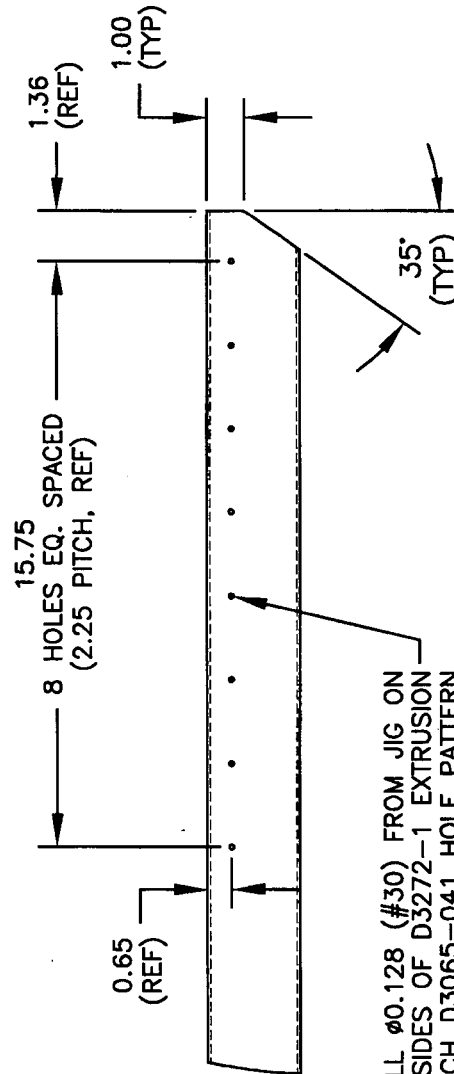


DETAIL C

**B D3272-1 STEP**

(MAKE FROM D2622-120 STEP EXTRUSION)

5782



DRILL  $\phi 0.128$  (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

DETAIL C

(SCALE 1:5)

RELEASED

07.06.04 [Signature]

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Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
	X							D350-591-212	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
		X						D350-591-213	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
			X					D350-591-214	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
				X				D350-591-215	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
					X			D350-591-216	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
						X		D350-591-311	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
							X	D350-591-312	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

\*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

51782